

# Work Order ID 82264

April-03-12 10:03:36 AM

Item ID: D4624-1  
Revision ID: ~~PRELIM~~  
Item Name: Mounting Plate

Start Date: 3/27/12 Start Qty: 1.00 \*1\*  
Required Date: 4/10/12 Req'd Qty: 1.00 \*1\*  
Reference:

Approvals: Process Plan: *h* Date:   
QC: Date:

Sequence ID/ Work Center ID	Operation Description
Draw Nbr	Revision Nbr
D4624	<i>PAI</i> <i>REV. A</i> <i>12.04.08</i>

\*100\*

Waterjet  
FLOW CNC Waterjet

FLOW WATER JET

Memo  
1-Cut as per Dwg D4624  
Dwg Rev: *PAI*  
Prog Rev: *PAI*  
2-Deburr as required

110

\*110\*

QC  
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Accept

\*82264\*

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

0.00

0.00

0.00

0.00

~~PRELIMINARY ISSUE~~

*12.04.08*  
*ECN 12-558*  
Page 1

*1B 12-3-09*

*1B 12-3-09*

# Work Order ID 82264

April-03-12 10:03:36 AM

\*82264\*

Page 2

Item ID: D4624-1  
Revision ID: PRELIM  
Item Name: Mounting Plate

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Start Date: 3/27/12 Start Qty: 1.00 \*1\*  
Required Date: 4/10/12 Req'd Qty: 1.00 \*1\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:  
QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

-inspects to PL

\*120\*

QC

Memo

0.00

8.7/03/17

Quality Control

160

Chemical Conversion Coat per QS1005 4.1

0.00

\*160\*

HandFinish

Memo

0.00

Hand Finishing

1 BL 12-4-3

170

QC7-Inspect Chemical Conversion Coat

0.00

\*170\*

QC

Memo

0.00

Quality Control

1X of m/l 12/04/03

# Work Order ID 82264

**\*82264\***

Page 3

April-03-12 10:03:36 AM

Item ID: D4624-1  
Revision ID: PRELIM  
Item Name: Mounting Plate

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Start Date: 3/27/12 Start Qty: 1.00 **\*1\***  
Required Date: 4/10/12 Req'd Qty: 1.00 **\*1\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: *GA*

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

*1204.05*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*12/4/10*

POSITIVE RECALL  
EFFECTIVE *12/4/10* AUTH *u*  
RELEASED *h* DATE *1204.04*  
EGW#12-558

*MUF*  
*12-04-05*

# Picklist Print

April-03-12 10:04:13 AM

Page 1

Work Order ID: 82264

Parent Item: D4624-1

Parent Item Name: Mounting Plate

Start Date: 3/27/12

Required Date: 4/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-27 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No			100	sf	42.0000	5.9	6.2105263			
6061T6 SHEET .250													

12-3-09

Location

Loc Qty

Loc Code

MAT021

42

116808

16.5

121194

25.5

6.5

# LOT TRACKING !!

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date
M6061T6S.250	82264	-6.5	121194	3/29/12 2:26:42 PM

# Work Order Summary

April-03-12 10:05:39 AM

Page 1 of 1

Criteria : Work Order ID: 82264 Item ID: D4624-1 Product Family SMALL FAB  
 Work Order Start Dates 3/27/12 to 3/27/12 11:59:59 PM Work Order Required Dates 4/10/12 to 4/10/12  
 11:59:59 PM

All References

Work Order Status Released

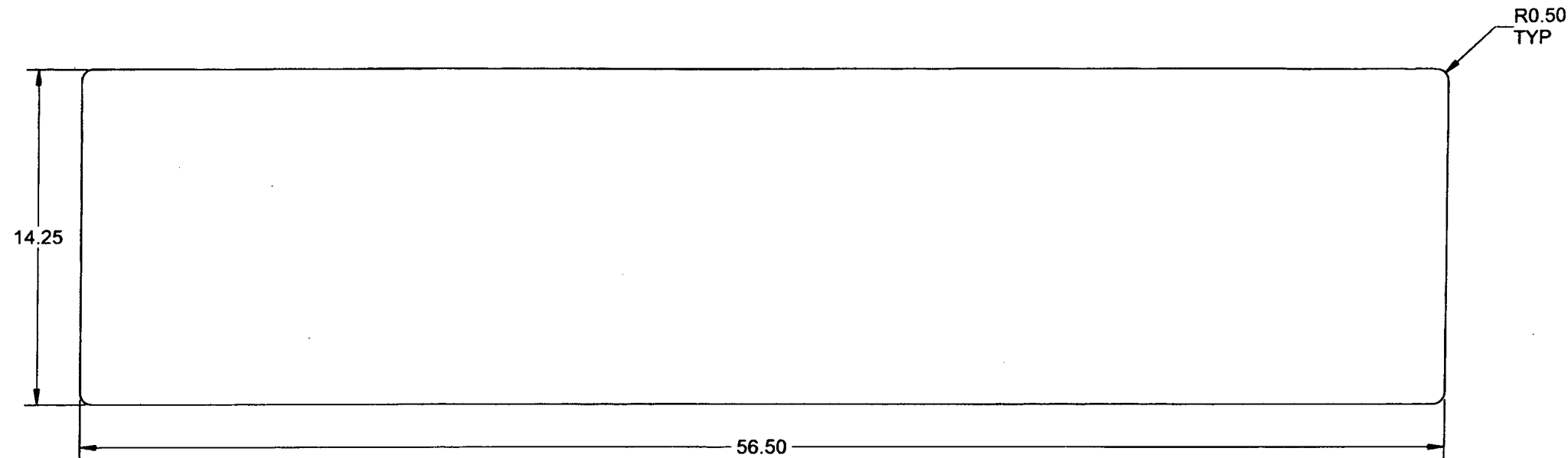
<b>Work Order ID</b>	82264	<b>Required Qty</b>	1.0000	<b>Status Code</b>	Released
<b>Item ID</b>	D4624-1	<b>Accepted Qty</b>	0.0000	<b>Scrap Qty</b>	0.0000
<b>Item Name</b>	Mounting Plate				
<b>Current Acct Value</b>	\$69.849				

<b>Start Date</b>	3/27/12	<b>Required Date</b>	4/10/12	<b>Completed Date</b>	
Standard	<b>** Actual **</b>	<b>** Acct. Value **</b>	<b>** Variance **</b>	<b>** Variance % **</b>	
<b>Direct Costs</b>	<b>Total</b>	<b>Each</b>	<b>Each</b>	<b>Each</b>	<b>Each</b>
<b>Material</b>	\$84.765	\$0.000	\$69.849	\$69.849	100.00%
<b>Labor</b>	\$2.383	\$0.000	\$0.000	\$0.000	0.00%
<b>Outplant</b>	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>Variable Burden</b>	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>Fixed Burden</b>	\$7.622	\$0.000	\$0.000	\$0.000	0.00%
<b>Material Burden</b>	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>** Total **</b>	\$94.769	\$0.000	\$69.849	\$69.849	

<b>Item ID/Item Name</b>	<b>Required Qty</b>	<b>Issue Code</b>	<b>Issue Date</b>	<b>Issued Qty</b>	<b>Cost Amount</b>
M6061T6S.250					
6061T6 SHEET .250	6.2105		3/29/12	6.5000	\$84.765
<b>Total Matl Amts:</b>					\$84.765

## Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BLEC01	3/29/12											
100			0.00	0.00	0.12	0.12	1.00	\$0.000	\$2.383	\$7.622	\$0.000	\$10.00
<b>Total:</b>			0.00	0.00	0.12	0.12	1.00	\$0.000	\$2.383	\$7.622	\$0.000	\$10.00



**D4624-1 MOUNTING PLATE**

RELEASE  
2012-04-04  
MP

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11  
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF. DART SPEC. M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4624-1" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 19.60 lbs

A	NEW ISSUE		MB	12.03.26
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 1	
DRAWN				
CHECKED	DRAWING NO. D4624		SCALE NTS	
MFG. APPR.				
APPROVED	TITLE SUPPORTING PLATE		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DE APPR.				
DATE	12.03.26			